

Date: Wednesday, 07/05/2008 2:38:17 PM
 User: Jean-Luc Menard

Process Sheet

OK

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BACK LEG FITTING
 Job Number : 39109
 Estimate Number : 13293
 P.O. Number :
 This Issue : 07/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run :
 Written By : *JLM/07-05-07*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-05-01 JLM Verified By:EC

Part Number : D37641
 Drawing Number : D3764 PROTO
 Project Number : N/A
 Drawing Revision : PROTO 08.04.23
 Material :
 Due Date : 14/05/2008 Qty: 5 Um: Each

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X02000 6061-T6 Bar 1.5 x 2.0



Comment: Qty.: 0.2625 f(s)/Unit Total : 1.3125 f(s)
 6061-T6 Bar 1.5 x 2.0
 Batch: *M18147*

JLM 08/05/15

5

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 2.95" long

JLM 08/05/15

5

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA741 Rev. *AA* & Dwg D3764Rev: *A*

2-Deburr per dwg D3764

JLM 08/05/15

5

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 08/05/15

5

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JLM/08-05-15

5

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 05-05-16

(A)

7.0

QC3

**ENGINEERING
APPROVAL**

INSPECT POWDER COAT/CHEMICAL CONVERSION



PS 06.05.29

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



PS 06.05.29

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



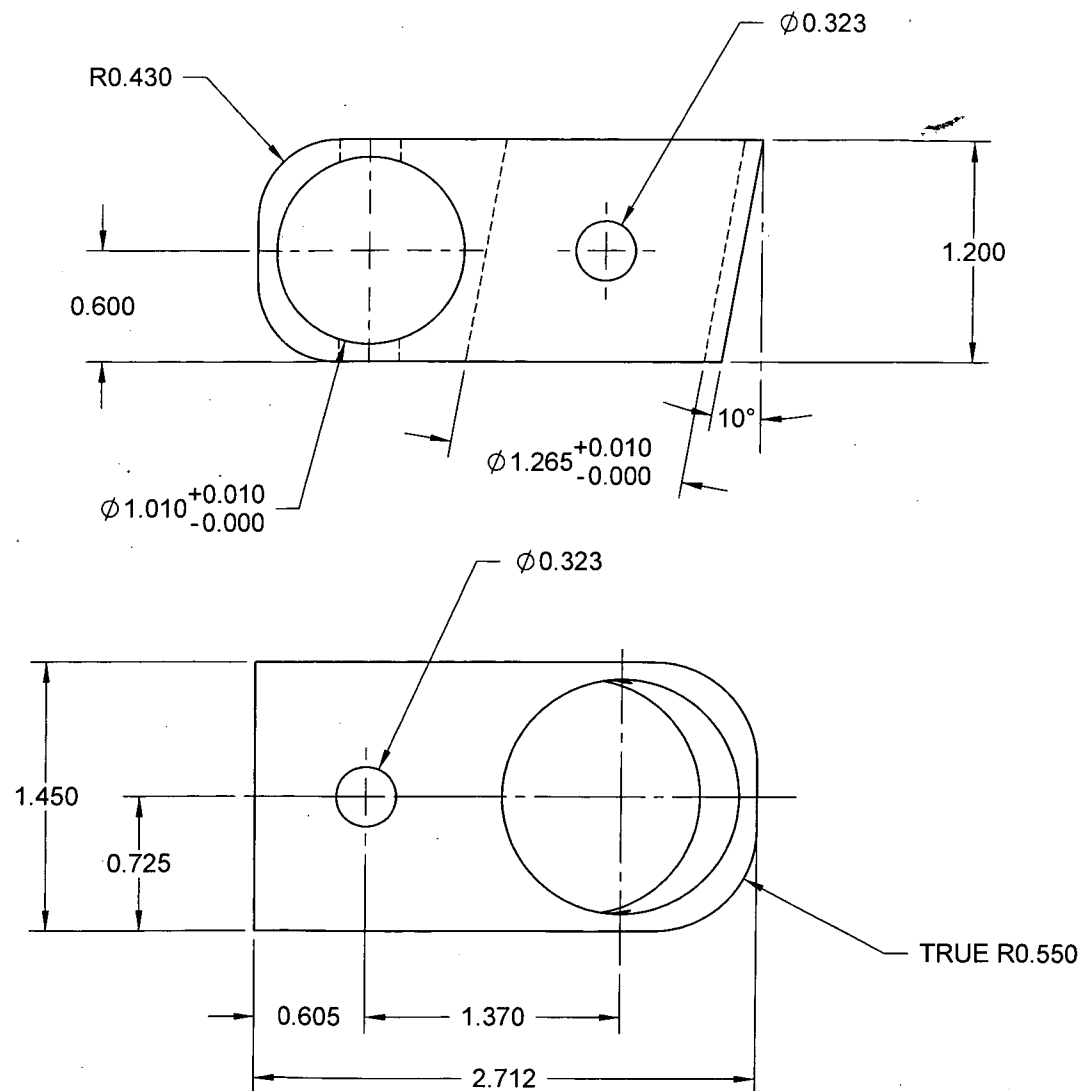
Comment: FINAL INSPECTION/W/O RELEASE

PS 08.05.29 Prototype

Job Completion



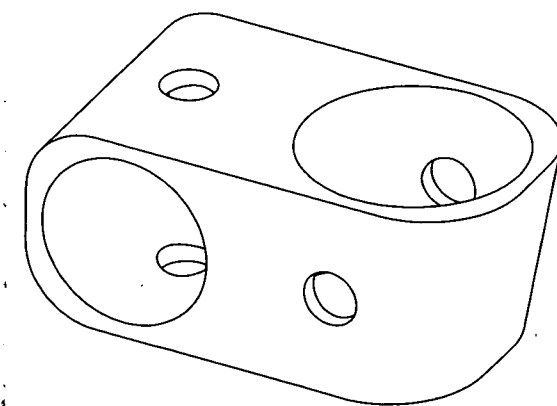
U 08.06.11



D3764-1 BACK LEG FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs



Est Done
1/27/1
1.500 x 2.00
DT9002

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING

08.04.23

| | | | |
|------------|-----------------|---|--------------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3764 | SHEET 1 OF 1 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BACK LEG FITTING | 1:1 |
| DATE | 08.03.24 | COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

Receiving Report

Date: 05/07/25
 Supplier: Copper + Brass

Batch No: M18147
 Dart P/O: 7008385

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐
 Q.C. Inspection [Signature]

Discrepancies

| Part No. | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|----------|-------------|------------------|-------------------|-------------------|----------------|----------|
| M606176B | 2.00 x 4.00 | 24 | 12 | | 12 | |
| | | | | | | |
| | | | | | | |

TSR No. _____

Initials of receiver (if shipment OK) DC

Production/Admin: _____
 Date: 05/07/28
 Received/Costing: 2-8385
 Initial: [Signature]
 H:\ISO9000\Forms\Purchase\RECREPORT rev B

Accounting: _____
 Date: _____
 AP/MR: _____
 Initial: _____



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

| | |
|------------------|------|
| OUR ORDER NUMBER | ITEM |
| 503147 | 1 |

| | | | |
|----------------------------|----------------------|--------------------|------------------|
| BILL TO | MANIFEST NUMBER | DIE NUMBER | DATE OF SHIPMENT |
| Copper & Brass Sales, Inc. | 11868 | RB0138 | 7/11/2005 |
| SHIP TO | CUSTOMER PO | ALLOY / TEMPER | SALESMAN |
| Copper & Brass Sales, Inc. | CF4418 | 6061-T6511* | R. Randolph Weis |
| | CUSTOMER PART NUMBER | DESCRIPTION | |
| | 020387-7 | SCRB 1.500 x 2.000 | |

| |
|-----------------------|
| CERTIFICATION |
| ASTM-B221-04a Stencil |
| SPECIFICATION |
| AMS-QQA-200/8 |

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown.

Mechanical Properties

| Lot No. | Test No. | Test Date | Ultimate Tensile Strength (KSI) | Yield Strength (KSI) | Percent Elongation |
|------------|----------|-----------|---------------------------------|----------------------|--------------------|
| 503147-1-1 | 1 | 07/07/05 | 54.5 | 50.0 | 15 |
| 503147-1-1 | 2 | 07/07/05 | 54.5 | 50.6 | 16 |
| 5147-1-1 | 3 | 07/07/05 | 54.5 | 50.4 | 15 |
| 147-1-1 | 50 | 07/07/05 | 55.4 | 51.8 | 17 |
| 147-1-1 | 51 | 07/07/05 | 56.0 | 52.6 | 17 |
| 147-1-1 | 52 | 07/07/05 | 55.1 | 51.6 | 18 |

SOLD TO Copper & Brass Sales
DATE 7-19-05
CUSTOMER P.O. 2008385
CUSTOMER P/N _____
SHIPPER NO. 251797
QUANTITY 2PCS
BY N. Dwyer
COPPER and BRASS SALES INC.

PA
08.05.29

Chemical Composition for Alloy 6061

| | Si | Fe | Cu | Mn | Mg | Cr | Zn | Ti | B | Zr | OtherEach | OtherTotal |
|-----|------|-----|------|------|-----|------|------|------|---|----|-----------|------------|
| Min | 0.40 | | 0.15 | | 0.8 | 0.04 | | | | | | |
| Max | 0.8 | 0.7 | 0.40 | 0.15 | 1.2 | 0.35 | 0.25 | 0.15 | | | 0.05 | 0.15 |

Manager of Quality & Technical Services